







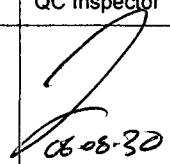
Sept. 1


Date: Tuesday, 15/08/2006 7:20:15 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : STEP WELDMENT	
Job Number : 28195			
Estimate Number : 10721			
P.O. Number :		Part Number : D34637	
This Issue : 15/08/2006 S.O. No. :		Drawing Number : D3463 REV.B	
Prsht Rev. : NC		Project Number : N/A	
First Issue : / / Type : SMALL / MED FAB		Drawing Revision : B	
Previous Run : 27804		Material :	
Written By :		Due Date : 31/08/2006 Qty: 10 Um: EACH	
Checked & Approved By :			
Comment : EST REV> A 05.11.18 new issue EC			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W120	Inventory 	
<p>Comment: Qty.: 1.0000 f(s)/Unit Total : 10.0000 f(s)</p> <p>AISI 304 SS seamless tubing 0.750 OD X 0.120 wall</p> <p>(M304TR0750W120)</p> <p>Batch: <u>11101945</u> FF 06.08.29 10</p>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1</p> <p>1-Drill hole as per dwg D3463</p> <p>2-Deburr</p> <p>3-Cut to 13.875"</p> <p>4-Bend end as per dwg D3463</p> <p>FF 06.08.30 10</p> <p>FF 06.08.29 10</p> <p>SB 01/08/30 10</p>			
3.0	QC5	INSPECT WORK TO CURRENT STEP 	
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>06.08.30 10</p>			
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 	
<p>Comment: CONVENTIONAL MILLING MACHINE</p> <p>1-Mill as per dwg D3463</p> <p>2-Deburr</p> <p>06/09/05 10</p>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-08-30	20	Drill hole during milling process. Perm. Change 					 06-08-30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/07
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:20:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28195

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Handwritten: 06/09/05 10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten: 5.6 06/09/05 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 35P*

Handwritten: 24/9/07 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Handwritten: 06/09/07 (15)

Job Completion



Handwritten: 06-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

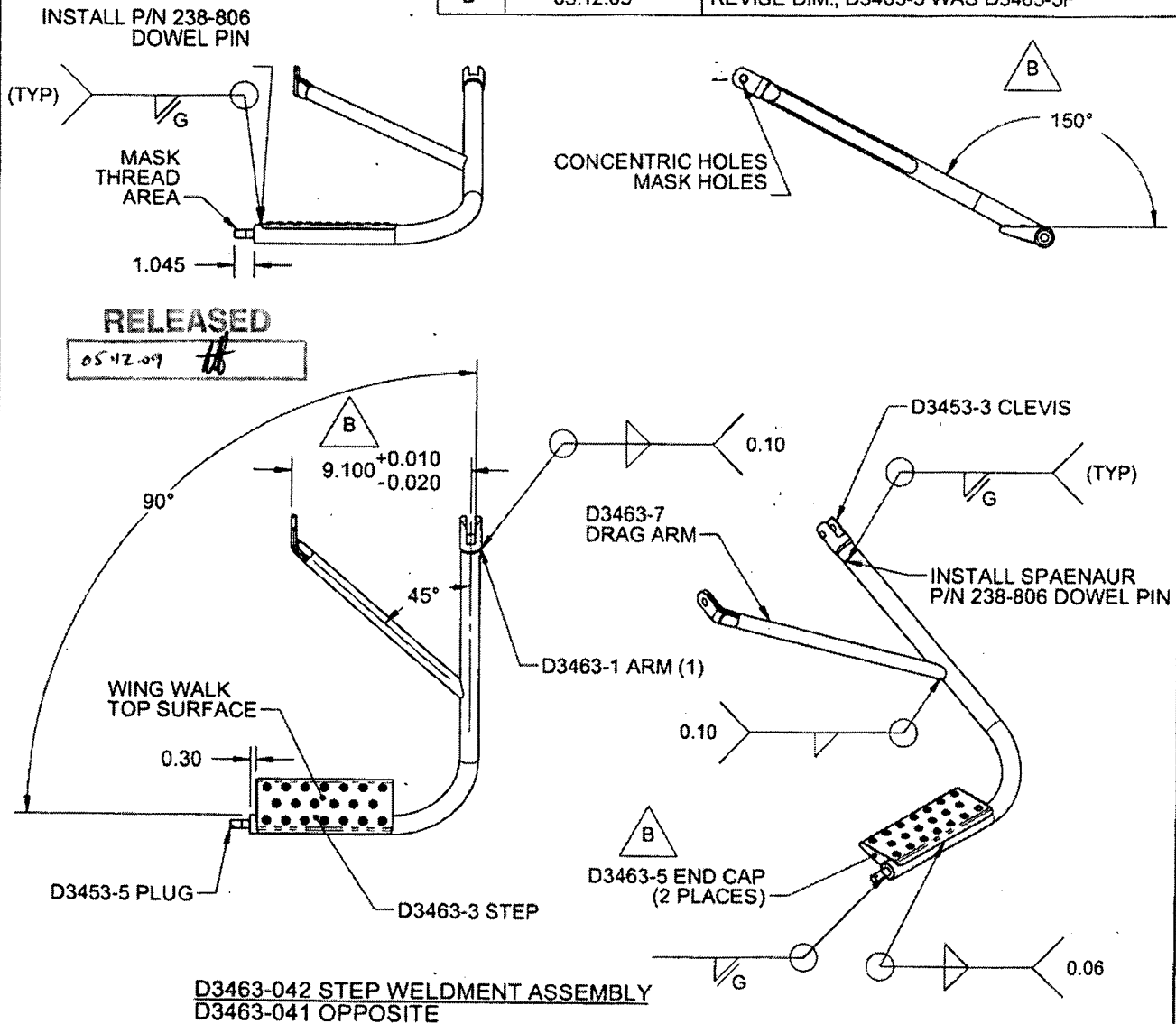
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

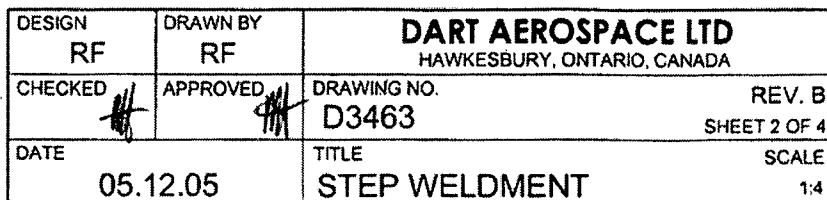
**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

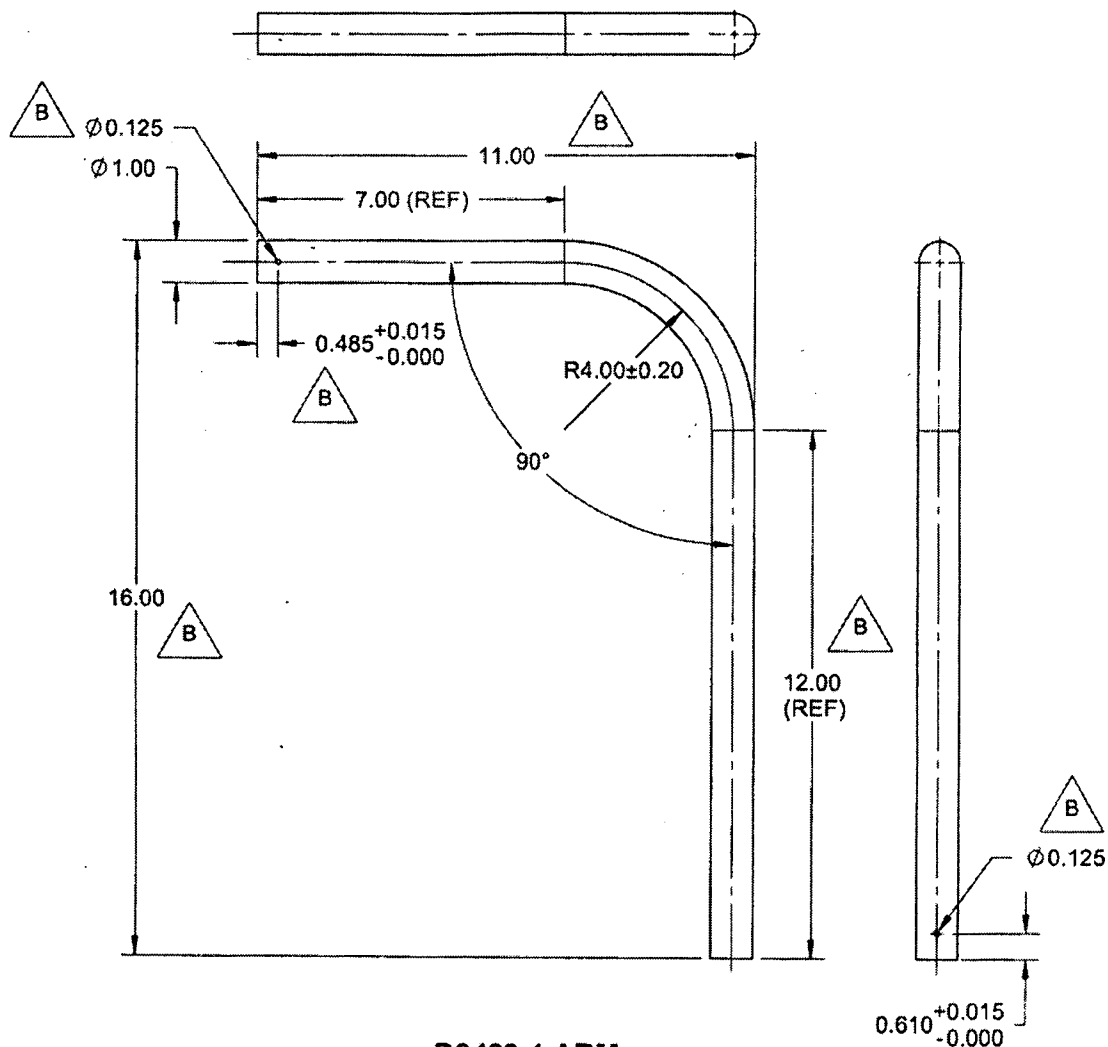
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05.12.09



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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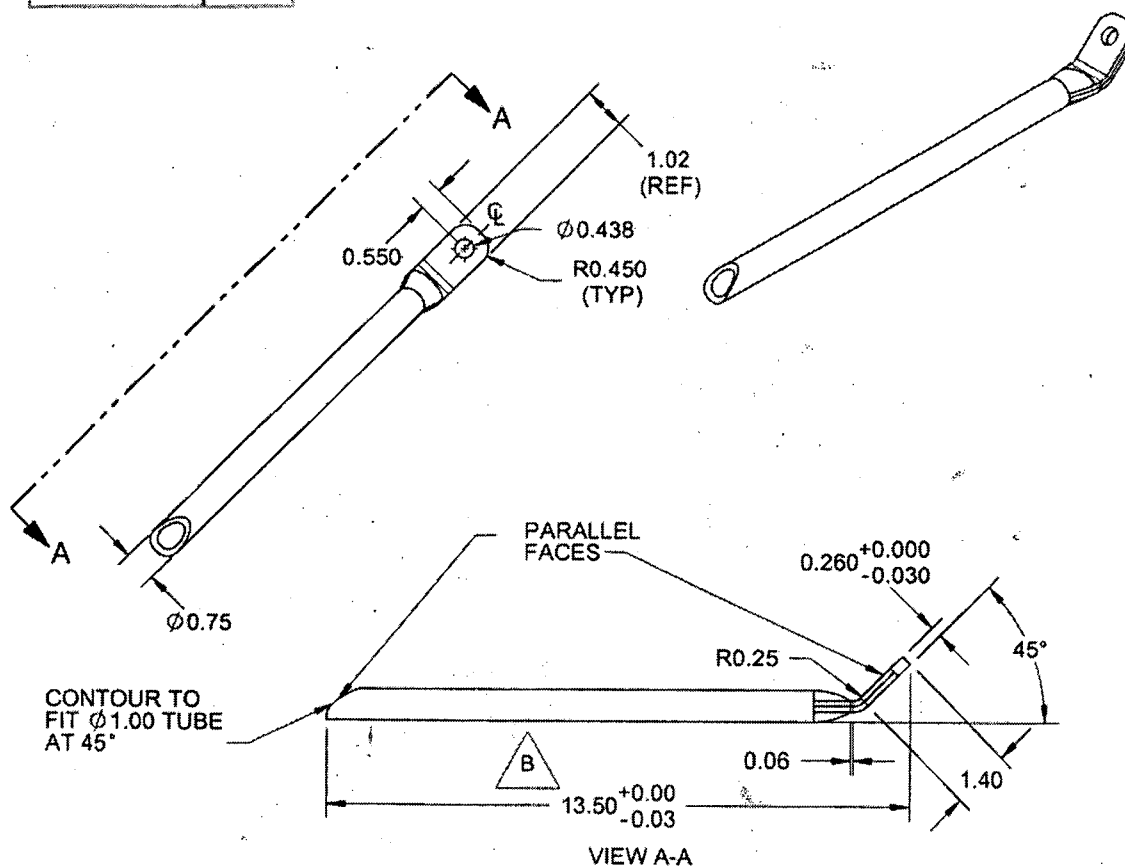
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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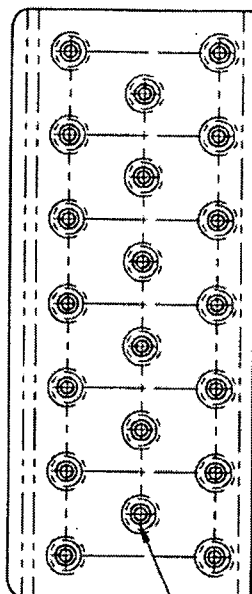
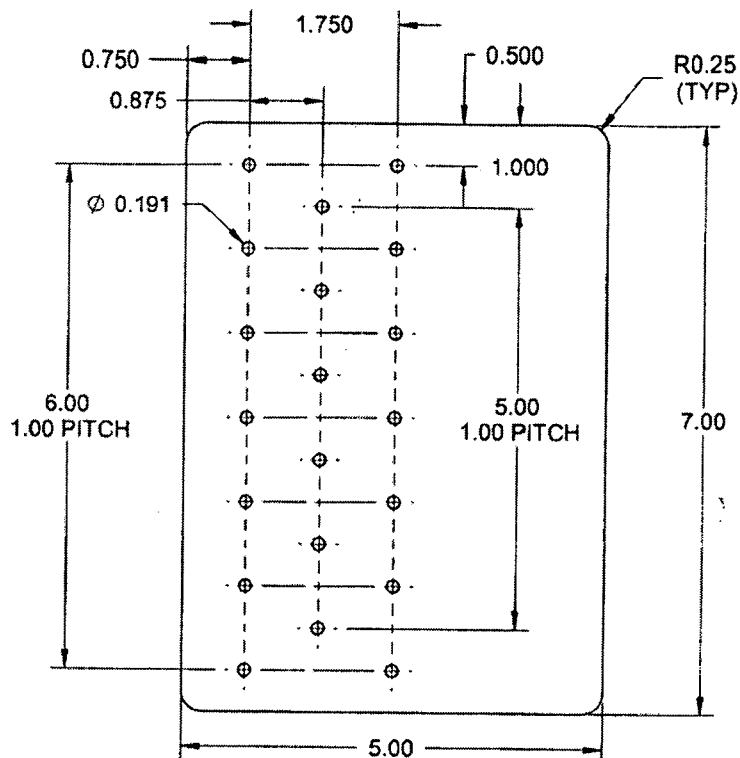
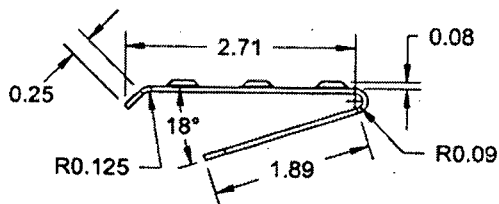
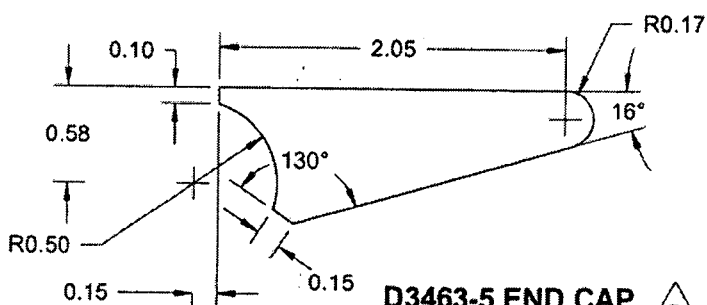
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

05.12.05 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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